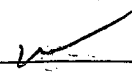
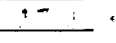


Date: Tuesday, 1/10/2006 11:01:29 AM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D206642341 - RTN 430
Job Number	: 25280		
Estimate Number	: 10804		
P.O. Number	: N/A	Part Number	: D206642341
This Issue	: 1/10/2006 S.O. No. : N/A	Drawing Number	: D206642341
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 12/16/2005 Type : N/A	Drawing Revision	: N/A
Previous Run	: 00015	Material	: N/A
Written By	: 	Due Date	: 12/23/2005
Checked & Approved By	: 	Qty:	2 Um: Each
Comment	:		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT RTN 430

2.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

BUFF SADDLE AREAS SMOOTH PER DRWG D2650

BE 06-01-10 @

3.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

ON B18614 - REMOVE DAMMAGED CROSSBOLT SPACERS

REPLACE D2649 AS NECESSARY QTY 3 B 26200

WELD PER DRWG D2650

ALUM ROD A/R Batch M15855

GRIND SURFACES & WELDS SMOOTH PER DRWG D2650

BE 06-01-10 @

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

QC 5/9

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Date: Tuesday, 1/10/2006 11:01:29 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206642341 - RTN 430

Job Number: 25280

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

REMOVE ALL HARDWARE (AFT CAP, WEARPLATES, SCREWS, WASHERS, PLUGS ETC..) DISCARD

SCREWS

RE-POWDER COAT AS PER RS1004

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

ASSEMBLE PER DRWG D2650 (RECORD HARDWARE)

P/N _____

B _____

P/N _____

B _____

P/N _____

B _____

WING WALK B _____

NOTE: *chan*

PH 07-05-03

Install Qty (1) P34.29-1 Wearpad

ext almost location (see attached)

9.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

INSPCT KIT FOR COMPLETENESS

RE-PACKAGE PER PPP

D206-642-341 CHG 002

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

INSPECT LEVEL 21

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: Date: 01/09/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
05-12-20	1	crack on the fwd G-H holes a bolt was hammered through the cross bolt spacer by the customer. (see photos) on 0206-642-341 B18614	<u> </u> 06-01-10	G-H Lugs were dry fitted onto the 206 skid and the holes line up perfectly. Re-work skid as per WRO See attached e-mail.	<u> </u> 06-01-10	<u> </u> 06-01-10	<u> </u> 06-01-10	<u> </u> 06-01-10
07-04-11	3.0	Replaced x-bolt spacers keep crack-free, due to re-weld and re-work.	<u> </u> 07-04-11	Scrap tubes eliminate to engineering lab. for tests, i setups.	N/A	<u> </u> 07-04-11	<u> </u> 07-04-11	<u> </u> 07-04-11

NOTE: Date & initial all entries

Jason Murdoch

From: Bill Beckett [bbeckett@dartaero.com]
Sent: January 10, 2006 7:08 AM
To: 'Linda lacelle'
Cc: 'Jason Murdoch'
Subject: RE: 206 gh lugs

Linda,
 Please go ahead with the repair when you have time.
 Bill

-----Original Message-----

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]
Sent: January 9, 2006 4:26 PM
To: 'Bill Beckett'
Cc: Linda lacelle
Subject: RE: 206 gh lugs

Just wondering if the tube was going to get repaired any time soon. I forgot about it....

jmurdoch@dartaero.com

Q.C.Inspector

From: Bill Beckett [mailto:bbeckett@dartaero.com]
Sent: December 22, 2005 11:20 AM
To: Linda Lacelle (E-mail)
Cc: 'David Shepherd'; Jason Murdoch (E-mail)
Subject: RE: 206 gh lugs

Linda,
 Let's have Barclay do this after Xmas.
 Bill

-----Original Message-----

From: David Shepherd [mailto:davids@dartaero.com]
Sent: December 22, 2005 10:17 AM
To: Bill Beckett
Subject: Re: 206 gh lugs

Assuming just the crossbolt spacer is damaged, I would drill it out and weld in a new one.

David

----- Original Message -----

From: Bill Beckett
To: 'David Shepherd'
Cc: 'Jason Murdoch'; Marc Bellavance (E-mail)
Sent: Thursday, December 22, 2005 5:47 AM
Subject: RE: 206 gh lugs

David,

Yes and yes.

It's clear that the mechanic who tried to install these was a moron, and used a large hammer rather than his coco. As I said, however, it is a little too tight without allowance for the paint. I'm quite sure that your average mechanic "coaxes" the bushing in with a blunt instrument presently and removes the paint.

I will review with Marc in the new year.

What do you think about the cross bolt spacer that was ripped open during this hammering? I can have Barclay have a look at it and try a repair, or if you have been through this before and feel we should just scrap it, that's what we will do.

Thanks,
Bill

-----Original Message-----

From: David Shepherd [mailto:davids@dartaero.com]

Sent: December 21, 2005 11:40 AM

To: Bill Beckett

Cc: Jason Murdoch

Subject: Re: 206 gh lugs

I think 0.006" on diameter would be OK. Most of the problems I have encountered installing these has to do with slight twisting/warping during welding. Is the bracket square? Are the holes in the tube aligned from side to side?

David

----- Original Message -----

From: Bill Beckett

To: David Shepherd (E-mail)

Sent: Wednesday, December 21, 2005 5:00 AM

Subject: FW: 206 gh lugs

David.

It would be good if we could open up the tolerances on the GH bracket holes. As Jason says, it is a very fiddly procedure to install the bushings and once the bracket is painted, well... I think we should open them up by 0.006 on diameter to account for paint.

Bill

-----Original Message-----

From: Jason Murdoch [mailto:jmurdoch@dartaero.com]

Sent: December 20, 2005 4:32 PM

To: davids@dartaero.com

Cc: BILL BECKETT; Linda Iacelle; Dale Trepanier

Subject: 206 gh lugs

Hi David,

I have a 206-642-341 return and as you can see from the pics. One cross bolt spacer has been hammered open on the inside. Bill and I tried a lug on the tube and found the fit to be very tight considering the lug wasn't painted. This is on the fwd ground handling location, and on the aft location the holes were damaged on the top due to hammering in the bushings. Any chance this should be repaired? Also I think the fit should more of a tolerance so the customers don't have to hammer on anything. What do you think? Pic 7 if you just move the lug over with a screw driver it lines up, and slide the bushing in.

jmurdoch@dartaero.com

Q.C. Inspector

Date: Tuesday, 12/20/2005 7:09:22 AM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206642341 - RTN 430

Job Number: 25280

Part Number: D206642341

Job Number:



Seq. #:

Machine Or Operation:

Description :

WING WALK B _____

7.0

QC3/5

INSPECT WORK/WING WALK



Comment: INSPECT WORK/WING WALK

REFERENCE ONLY

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

INSPCET KIT FOR COMPLETENESS

RE-PACKAGE PER PPP

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

INSPECT LEVEL 21

Job Completion



3.0

- Re-work B18614

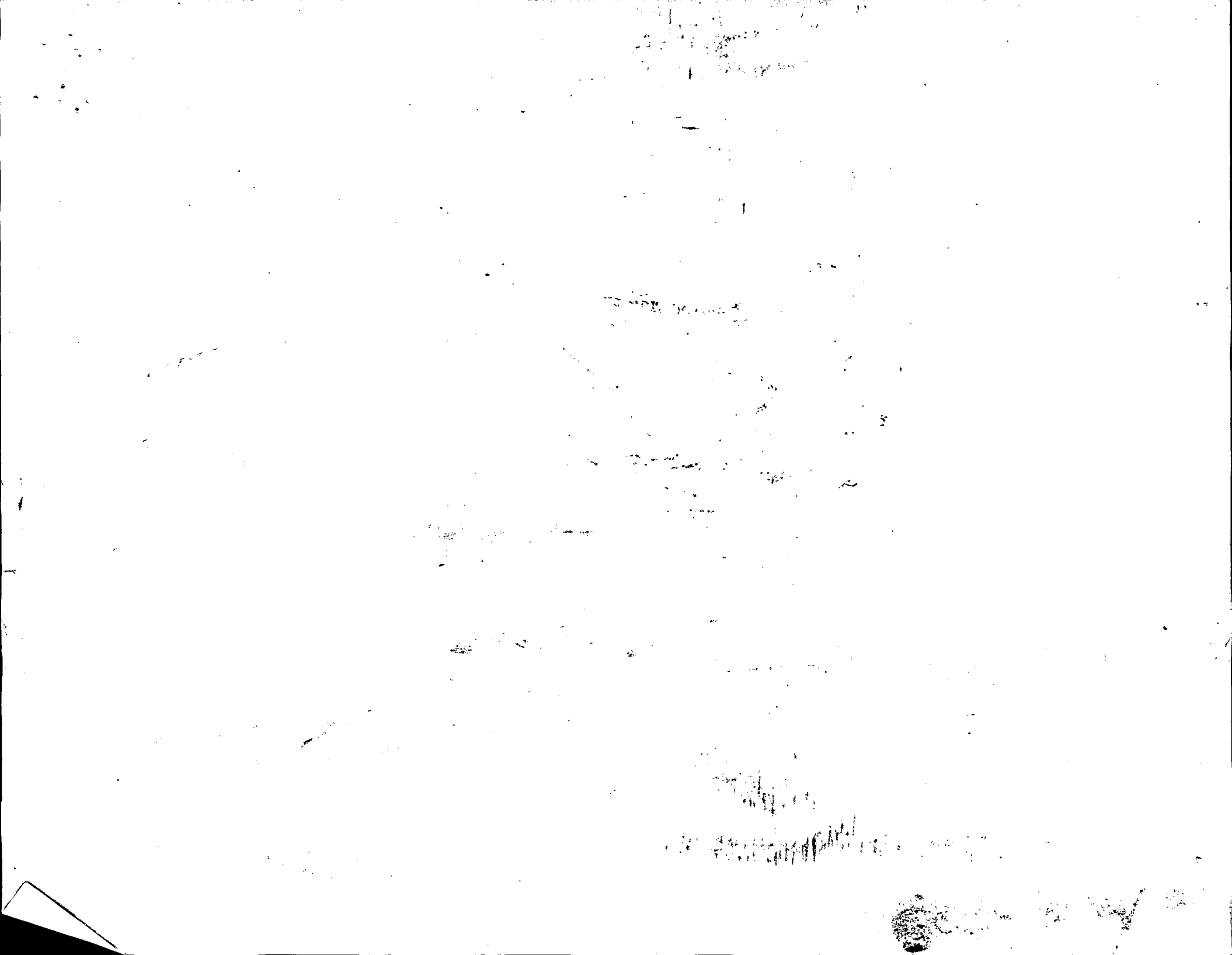
- remove damaged cross bolt spacers

- replace D2645 AS necessary - Qty _____ Bt# _____

- Weld AS per Dwg ~~D206642~~ D2650
AL Rod ~~Bt#~~ M# _____ A/R

* Grind ~~all~~ All surfaces & welds smooth AS per dwg ~~D206~~ D2650

- Inspect Qc 5/5



Date: Tuesday, 12/20/2005 7:09:21 AM
 User: Linda Lacelle

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd.
 Job Number : 25280
 Estimate Number : 10804
 P.O. Number :
 This Issue : 12/20/2005 S.O. No. :
 Prsht Rev. : NC
 First Issue : 12/16/2005 Type
 Previous Run : 00015

Drawing Name : D206642341 - RTN 430

Part Number : D206642341

Drawing Number : D206642341

Project Number :

Drawing Revision :

Material :

Due Date : 12/23/2005

Qty: 2 Um: Each

Written By :
 Checked & Approved By :
 Comment :

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT RTN 430

2.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

BUFF SADDLE AREAS SMOOTH

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

4.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

REMOVE ALL HARDWARE (AFT CAP, WEARPLATES, SCREWS, WASHERS, PLUGS ETC..) DISCARD

SCREWS

RE-POWDER COAT AS PER RS1004

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

ASSEMBLE PER DRWG D2650 (RECORD HARDWARE)

P/N _____

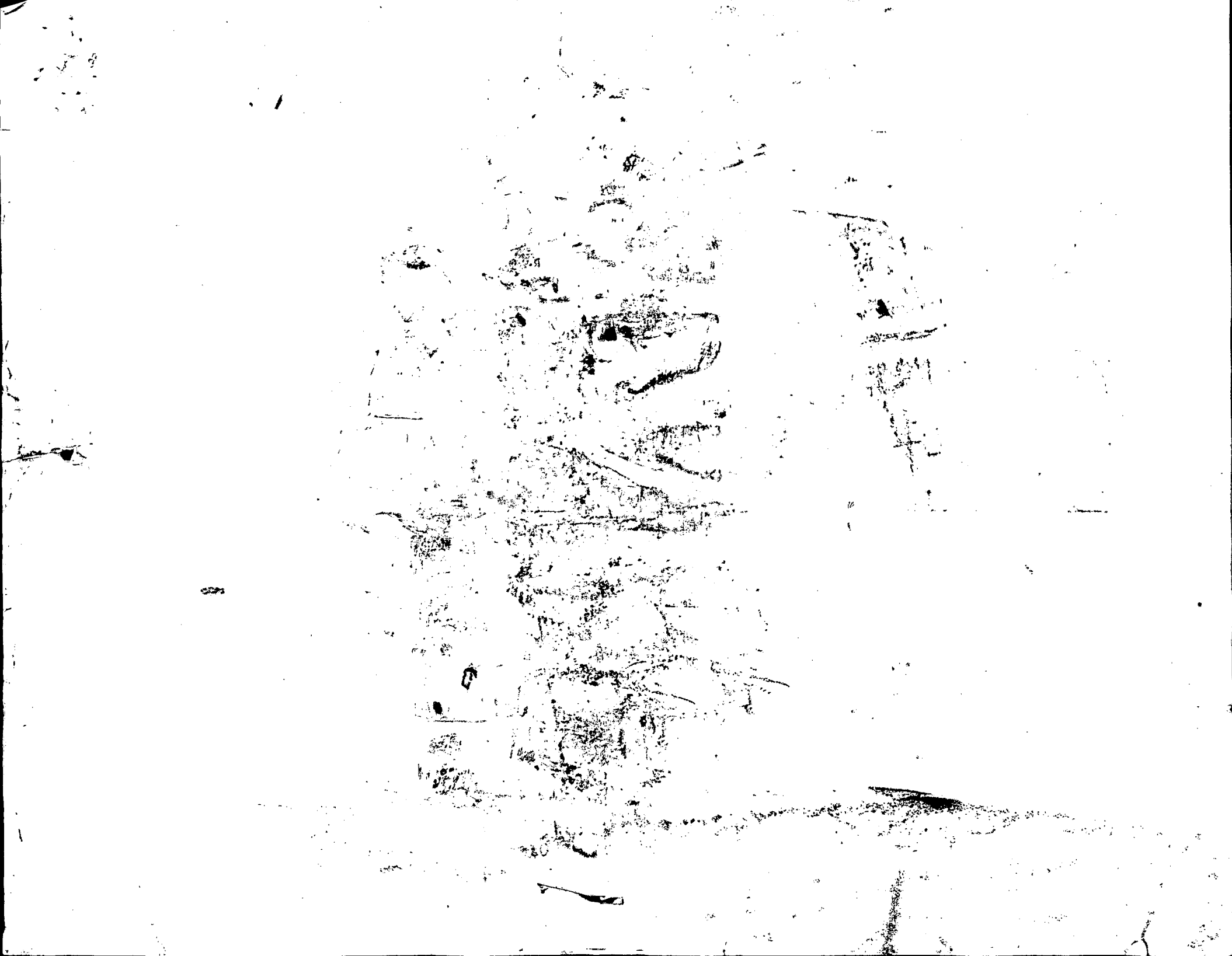
B _____

P/N _____

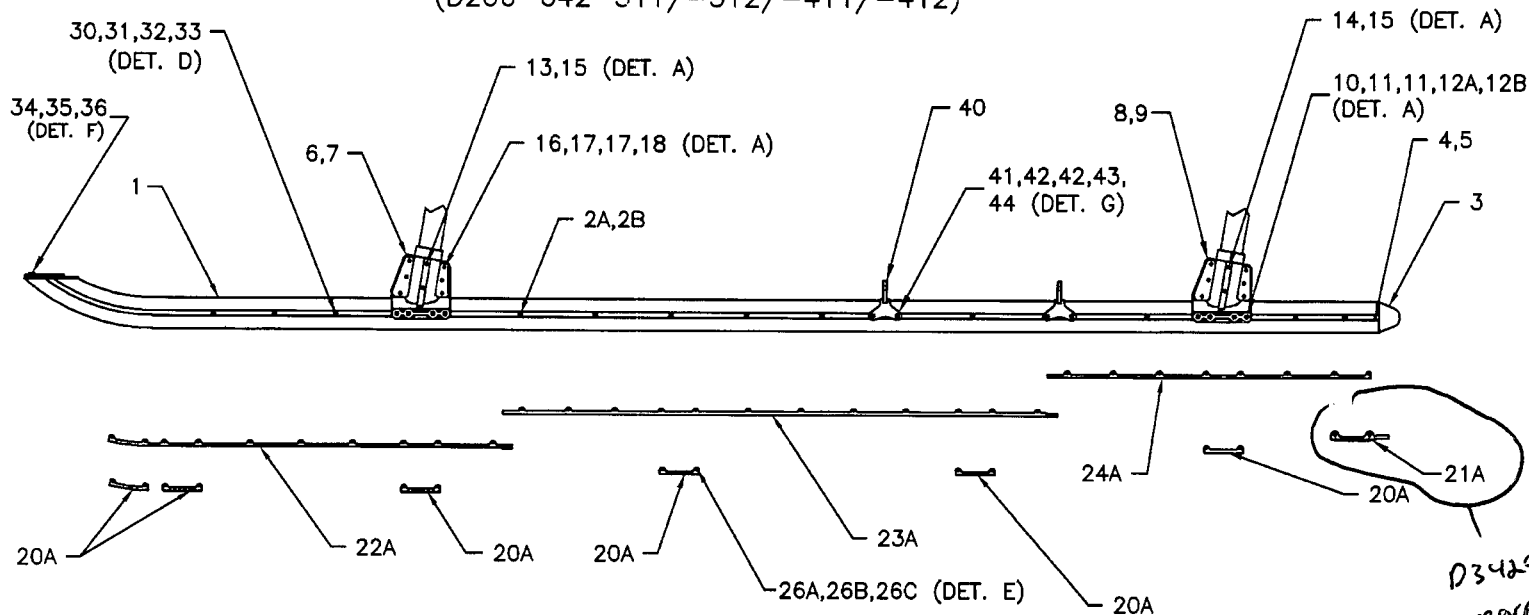
B _____

P/N _____

B _____



206 L/L-1/L-3/L-4/407 SKIDTUBES
(D206-642-311/-312/-411/-412)



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Revision: **K**
Date: 06.09.25